

Date: Friday, 22/05/2009 8:58:42 AM  
 User: Julie Dawson

## Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 48108 -1		
Estimate Number	: 10272		
P.O. Number	:	Part Number	: D2562001
This Issue	: 22/05/2009 S.O. No. :	Drawing Number	: D2562 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 42101	Material	:
Written By	:	Due Date	: 28/05/2009
Checked & Approved By	: <u>2100905-25</u>	Qty:	7 Um: Each
Comment	: Est F 02.04.15 Added dwg Rev.B1 NG		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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(7x)

Comment: Qty.: 1.7920 f(s)/Unit Total : 17.9204 f(s)  
 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall  
 Batch M111097

M-L 09/06/02

2.0	BRAKE NC	NC BRAKE
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(7x)

Comment: NC BRAKE  
 Punch to length as per Dwg D2562

M-L 09/06/02

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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(7x)

Comment: SMALL/MED FAB RESOURCE  
 1- Bend end as per Dwg D2562 Angle "D"  
 2-Deburr

7 M-L 09/06/02

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

09/06/02 (7x)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING  
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 8:30am  
 OVEN TEMPERATURE: 400°F  
 FINISH TIME: 9:00am

M-L 09-06-10 (7x)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 22/05/2009 8:58:42 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 48108

Part Number: D2562001

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



7

Comment: INSPECT POWDER COAT

FZ 09/06/10

7.0

PACKAGING 1

PACKAGING RESOURCE #1



7K

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 264

9/6/10

SD

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/10 FJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-06-10



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

FOR INSTALLATION INSTRUCTIONS/REQUIREMENTS AND TECHNICAL INFORMATION SEE APPLICABLE  
DART INSTALLATION INSTRUCTIONS.

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		D206-648-011	GROUND HANDLING KIT
	X	D206-648-013	GROUND HANDLING KIT
8	8	D2652	BUSHING
2		D2659	GHW LUG
	2	D3414-041	LUG ASSEMBLY
4		AN3-37A	BOLT
	4	AN3C37A	BOLT
	4	AN960C10	WASHER
4		AN960JD10	WASHER
4		MS21042-3	NUT (OR MS21042L3)
	4	MS21043-3	NUT

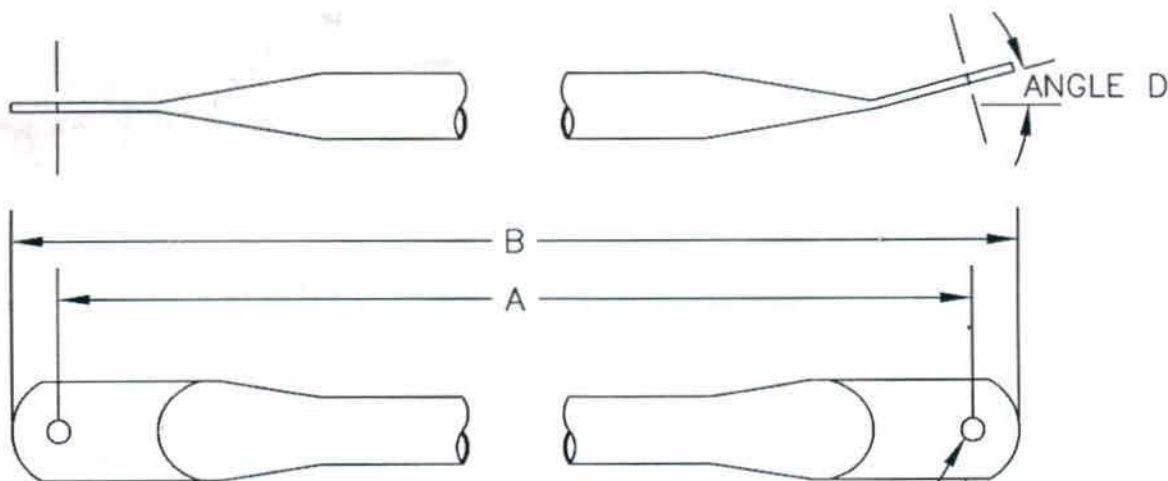
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WORK ORDER  
NO 48101

**RELEASED**  
09/02/16 M

B	INSTALLATION AND WEIGHT AND BALANCE INFORMATION TRANSFERRED TO DART INSTALLATION INSTRUCTIONS D206-642. ALL HARDWARE UPDATED TO SS HARDWARE.		AJS	08.09.24
A	NEW ISSUE		JB	97.11.03
REV.	DESCRIPTION		BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.	N/A	D206-648	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		GND HANDLING WHEEL (GHW) INSTL	NONE	
DATE	08.09.24		<small>COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

**DART**

DESIGN	CP	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAMKESBURY, ONTARIO, CANADA
DATE	05.05.18	DRAWING NO.	D2562	REV. D
		TITLE	STRUT	SHEET 1 OF 1
				SCALE 1:2
A	96.05.01	NEW ISSUE		
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)		
C	02.06.05	ADD -005; ADD FINISH		
D	05.05.18	ADD -007/-011/-013; UPDATE -005		



PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

**GENERAL NOTES**

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035) ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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